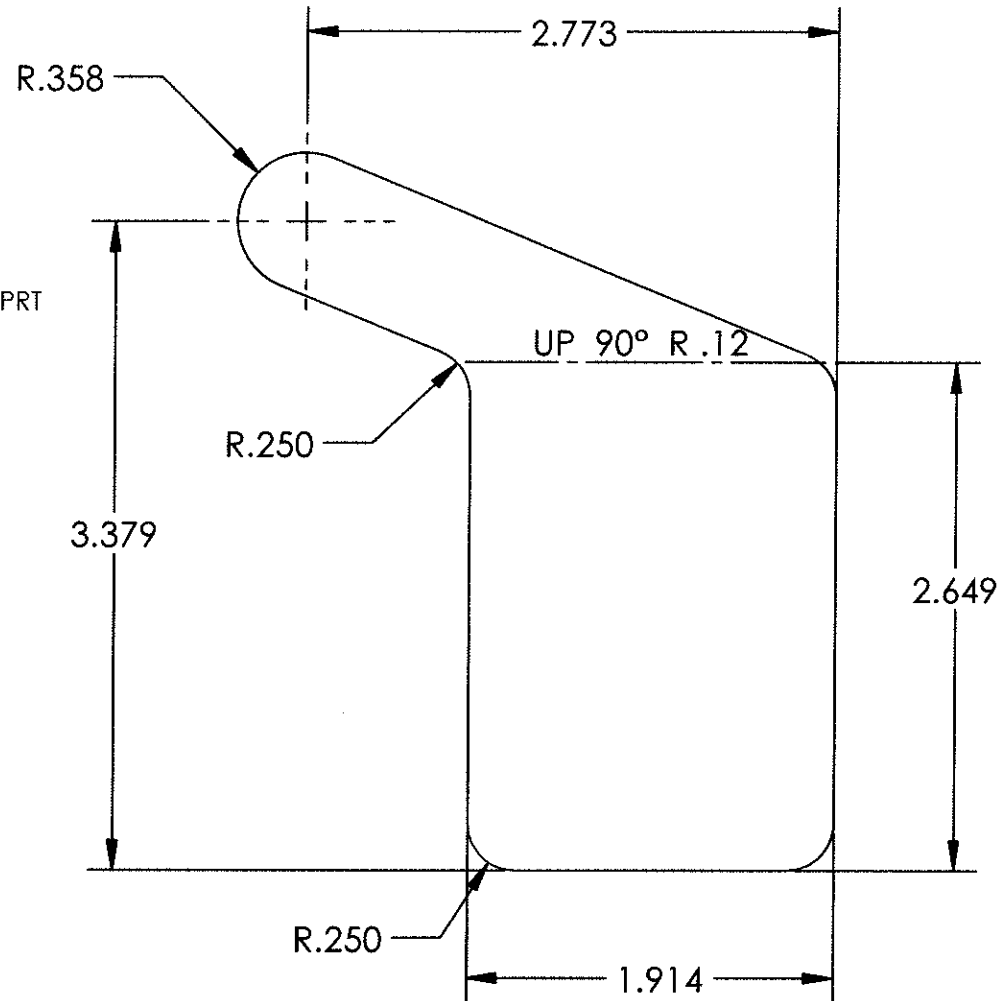
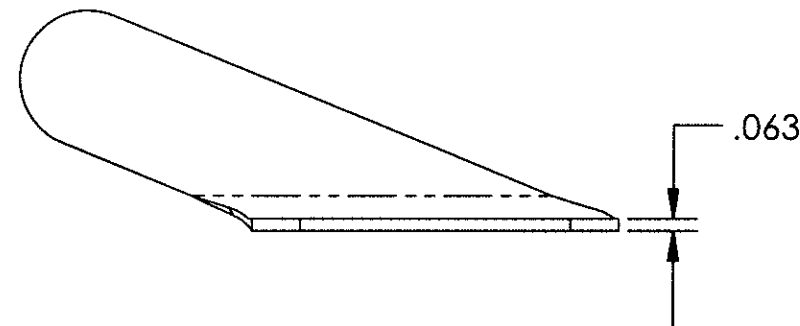
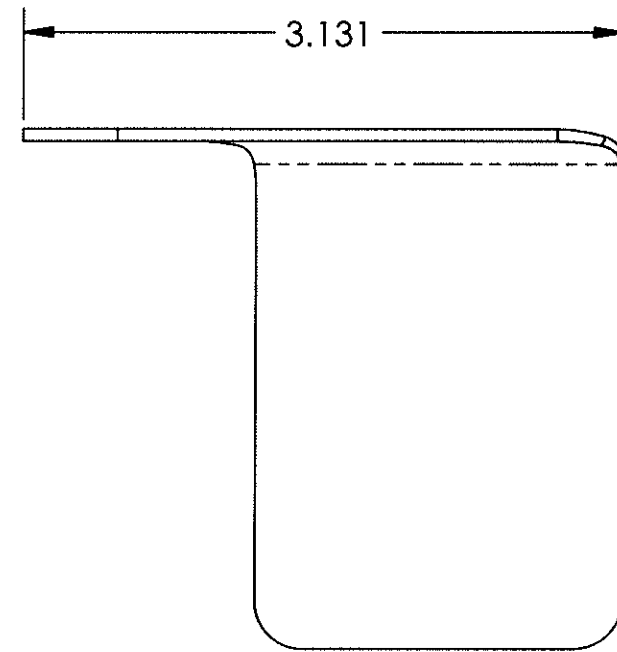


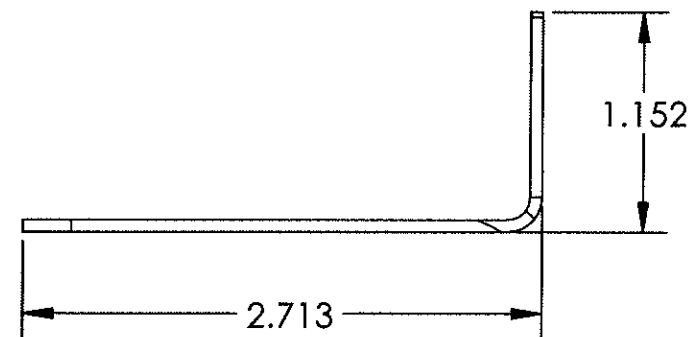
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NOTES: UNLESS OTHERWISE SPECIFIED

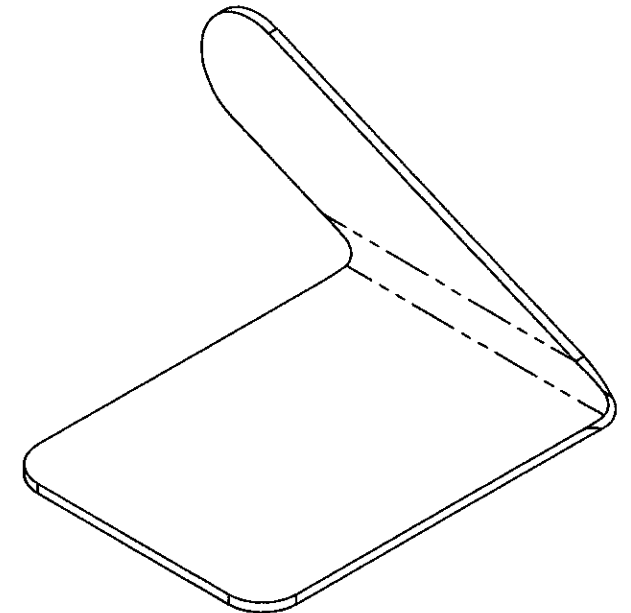
- 1 MATERIAL: ALUMINUM 2024-T3 PER AMS-QQ-A-250/4
- 2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK; PRETREAT PR-148 ADHESION PROMOTER, PRIME IAW MIL-P-23377J, TYPE I, CLASS N
3. DEBURR AND BREAK ALL SHARP EDGES
4. IDENTIFY IAW MPP-120. LASER ETCH P/N AND REVISION 12PT. CENTURY GOTHIC.
- 5 PART DIMENSIONS CONTROLLED BY CAD MODEL; FILE NAME: 649.4816 DOUBLER.SLDPRT
6. INSPECTION DIMENSIONS SHOWN WITH FINISH APPROX. 3-5 MIL MAX PER FACE.




649.4811  
FLAT PATTERN



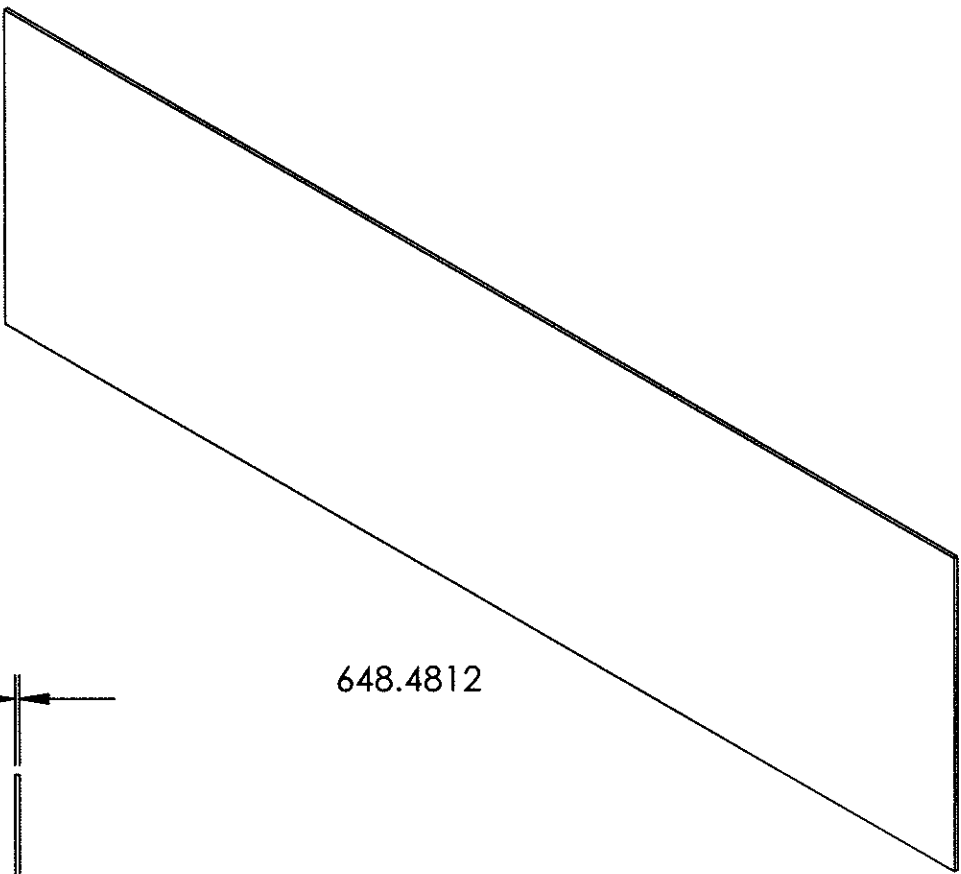
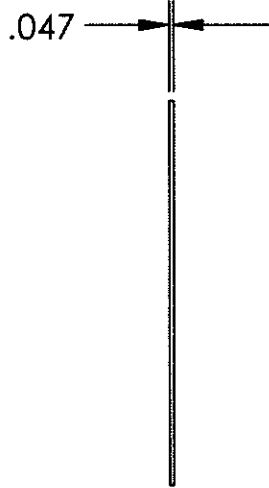
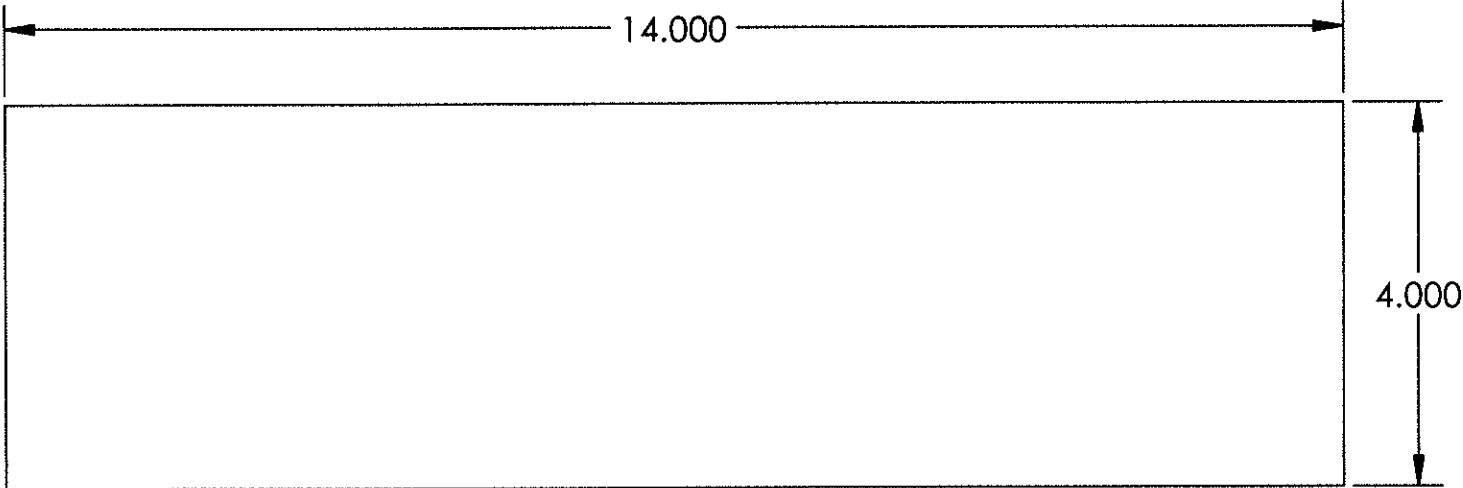
REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
	LAST PROTOTYPE REVISION: PR2		
N/C	INITIAL RELEASE	11-02-11	P. BRAVO
A	INCORPORATED ECN 03475	04-11-12	P. BRAVO
B	INCORPORATED ECN 05502	07-28-16	P. BRAVO
C	INCORPORATED ECN 05801	07-26-17	P. BRAVO
D	INCORPORATED ECN 05848, 05854	09-11-17	P. BRAVO
E	INCORPORATED ECN 05878, 05921	02-04-18	P. BRAVO




649.4811

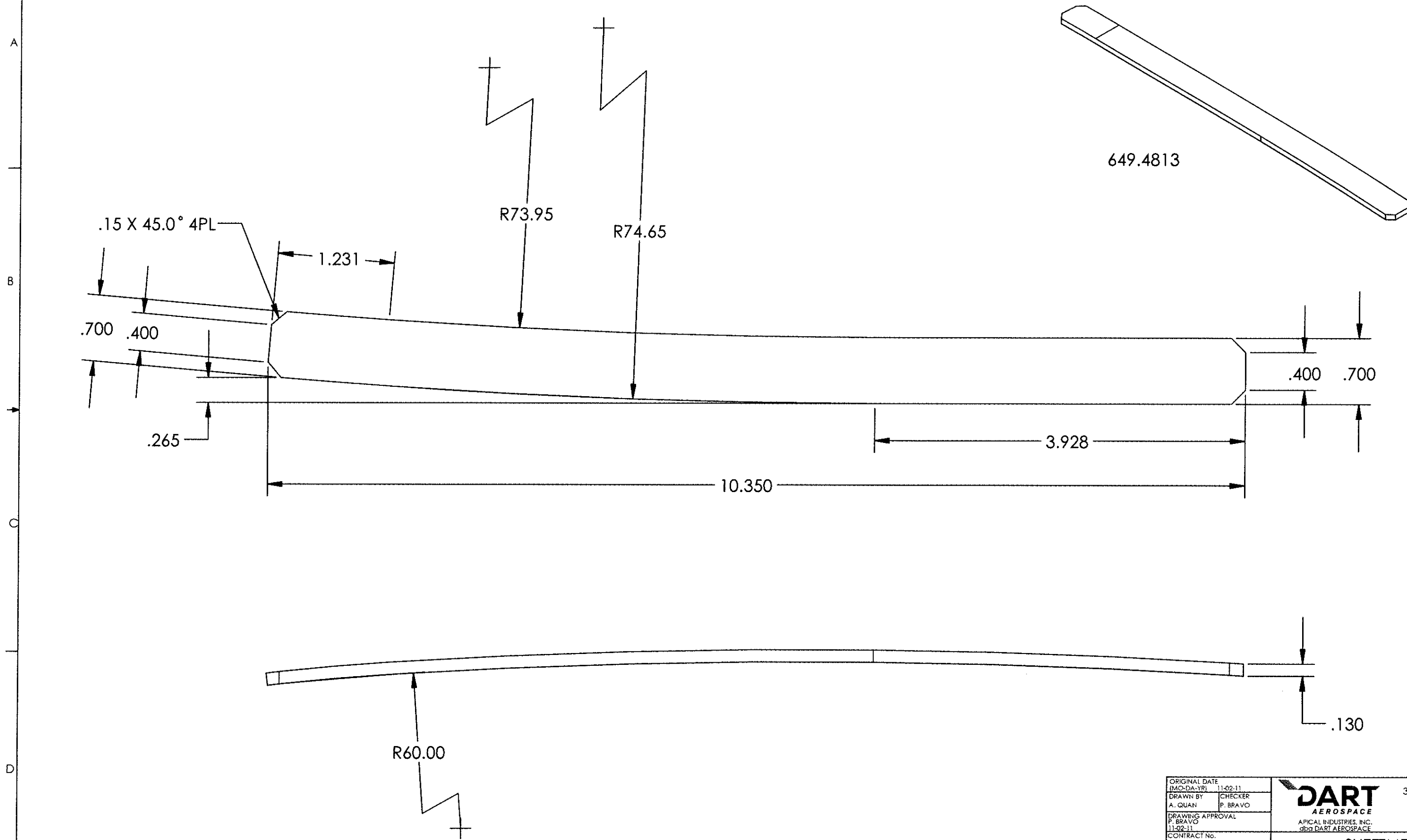
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		10	649.4819	SHIM	1	2
		9	649.4818	SHIM	1	2
		8	649.4817	SHIM	1	2
		7	649.4816	DOUBLER	1	2, 5
		6	649.4815	SHIM	1	2
		5	649.4814	DOUBLER	1	2
		4	649.4813	SHIM	1	2
		3	649.4812	SHIM	1	2
		2	649.4811	CLIP	1	2
		1		DELETED		
	FIND #		PART #	DESCRIPTION	MAT'L	SPEC.
	QTY	PARTS LIST				
	NEXT ASSY (S)	ORIGINAL DATE (MO-DA-YR)	11-02-11	 3030 ENTERPRISE CT., SUITE A VISTA, CA. 92081 (760)-724-5300		
	649.4700	DRAWN BY	A. QUAN			
		CHECKER	P. BRAVO			
		DRAWING APPROVAL	P. BRAVO			
		CONTRACT No.		SHEETMETAL		
		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE:	SIZE	CAGE CODE	DWG. NO.	REV.
		2 PLACE DECIMALS ±.03	B	07MZ6	649.4800	E
		3 PLACE DECIMALS ±.010	SCALE NONE			
		ANGLES ±.5°	SHEET 1 OF 8			

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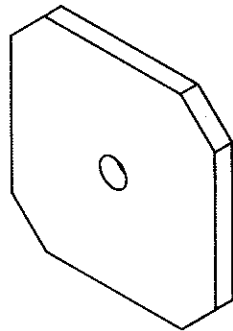
ORIGINAL DATE (MC-DA-YR) 11-02-11		 <b>DART</b> AEROSPACE APICAL INDUSTRIES, INC. dba DART AEROSPACE		3030 ENTERPRISE CT., SUITE A VISTA, CA. 92081 (760)-724-5300	
DRAWN BY A. QUAN	CHECKER P. BRAVO				
DRAWING APPROVAL P. BRAVO 11-02-11		<b>SHEETMETAL</b>			
CONTRACT NO.					
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.03 3 PLACE DECIMALS ±.010 ANGLES ± .5°		SIZE B	CAGE CODE 07MZ6	DWG. NO. 649.4800	REV. E
		SCALE NONE			SHEET 2 OF 8

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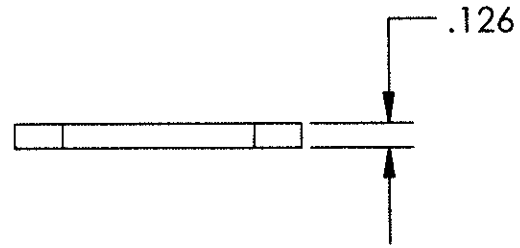


ORIGINAL DATE (MO-DA-YR) 11-02-11		<b>DART</b> AEROSPACE APICAL INDUSTRIES, INC. dba DART AEROSPACE		3030 ENTERPRISE CT., SUITE A VISTA, CA. 92081 (760)-724-5300	
DRAWN BY A. QUAN	CHECKER P. BRAVO				
DRAWING APPROVAL P. BRAVO 11-02-11		SHEETMETAL			
CONTRACT No.		DWG. NO. 649.4800			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.03 3 PLACE DECIMALS ±.010 ANGLES ±.5°		SIZE B	CAGE CODE 07MZ6	REV. E	SHEET 3 OF 8

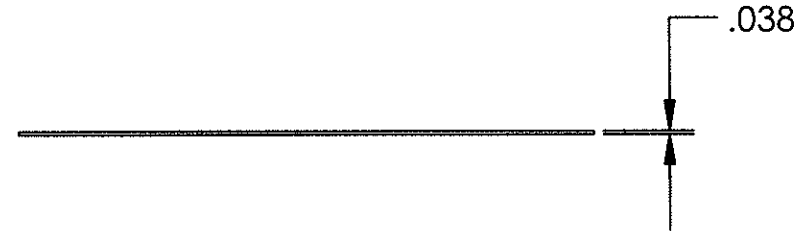
THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF APICAL INDUSTRIES DBA DART AEROSPACE. ANY REPRODUCTION IN PART OR WHOLE WITHOUT THE WRITTEN PERMISSION OF APICAL INDUSTRIES DBA DART AEROSPACE IS PROHIBITED.



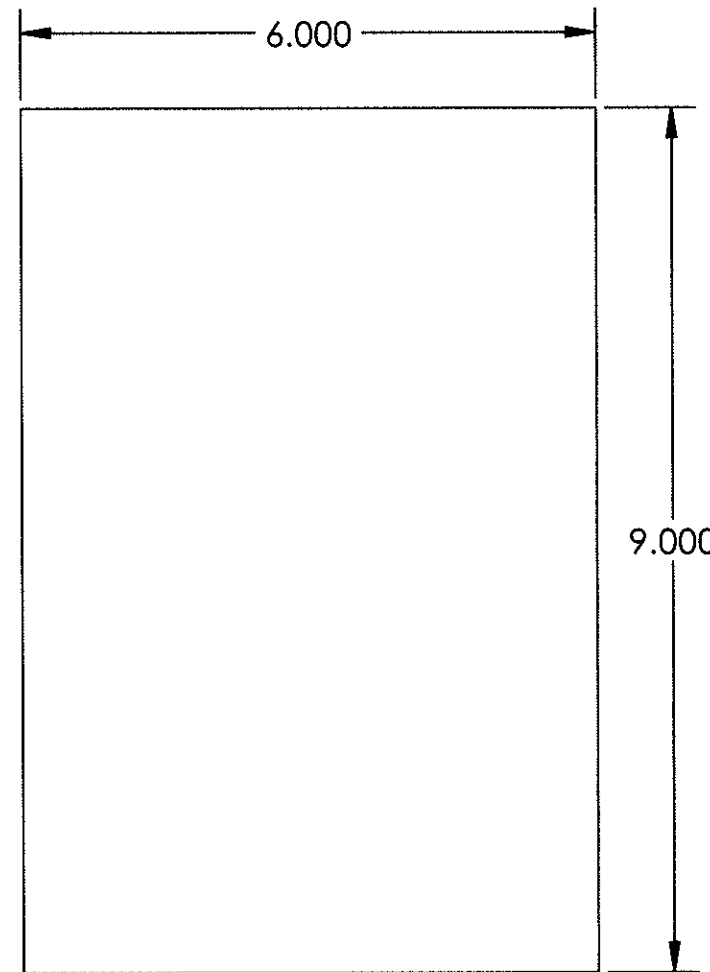
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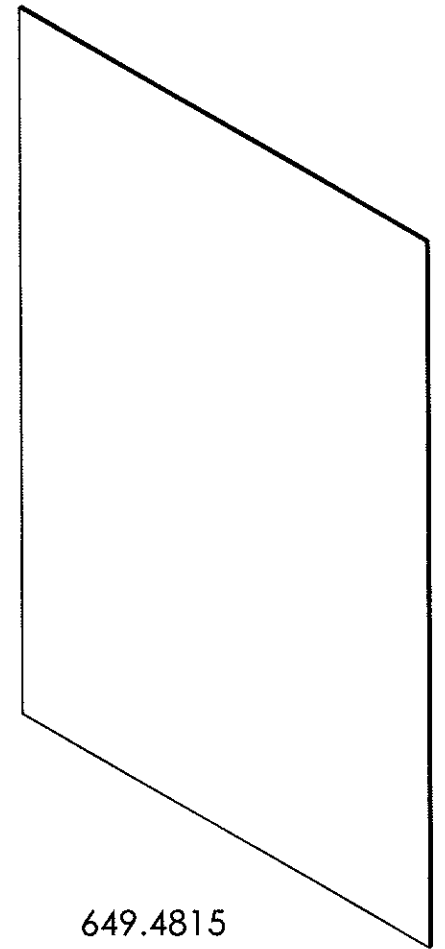


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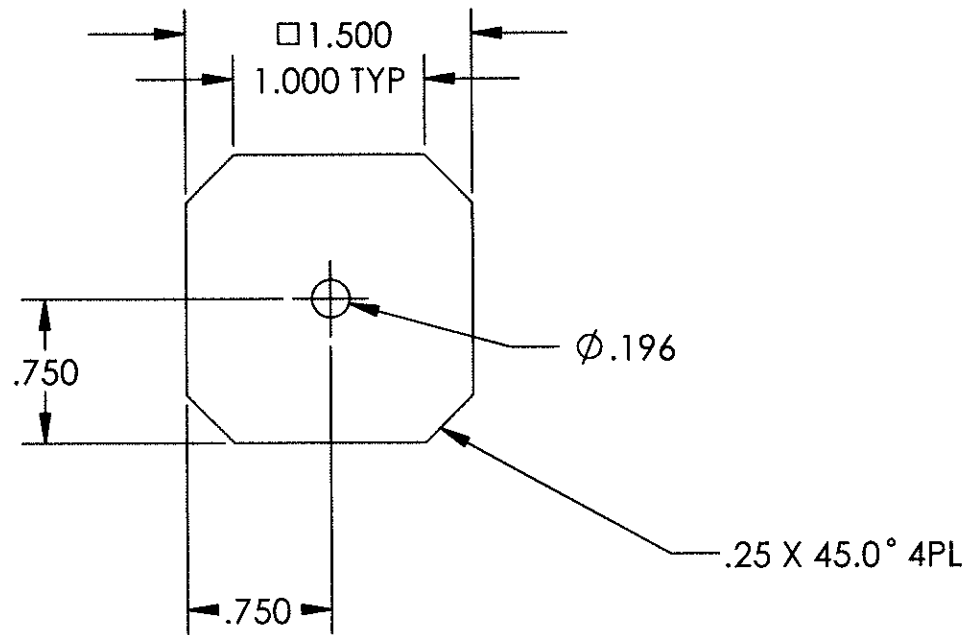


6.000

9.000



649.4815



1.500  
1.000 TYP

.750

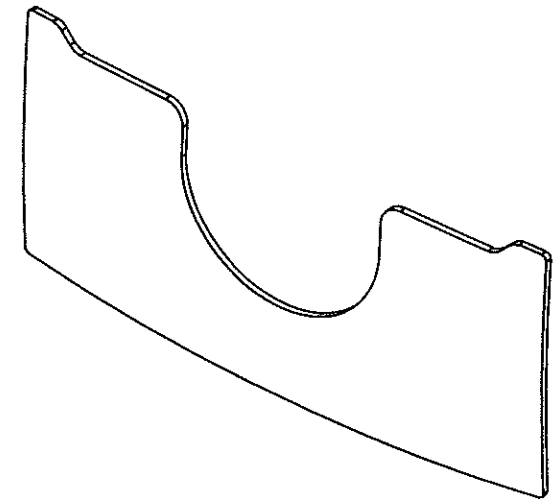
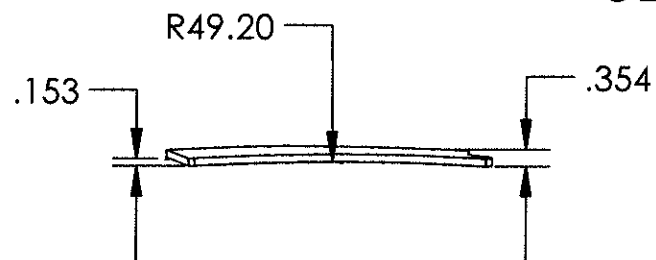
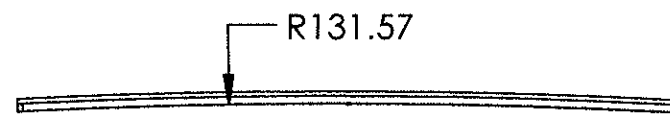
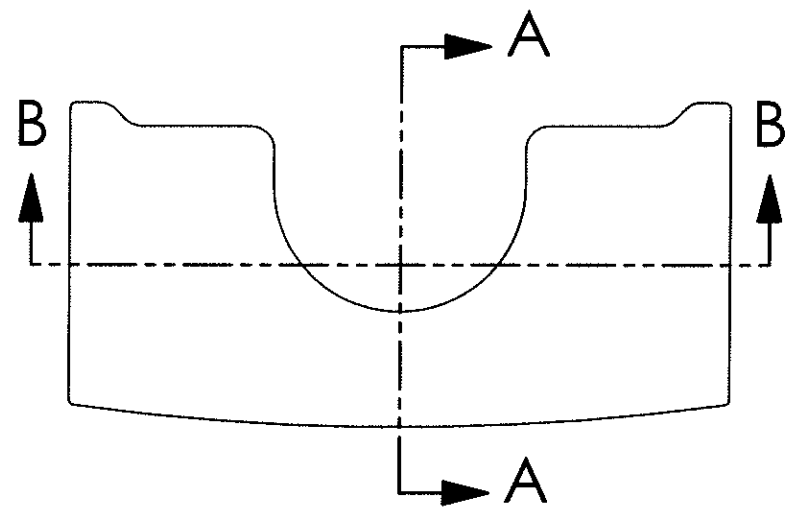
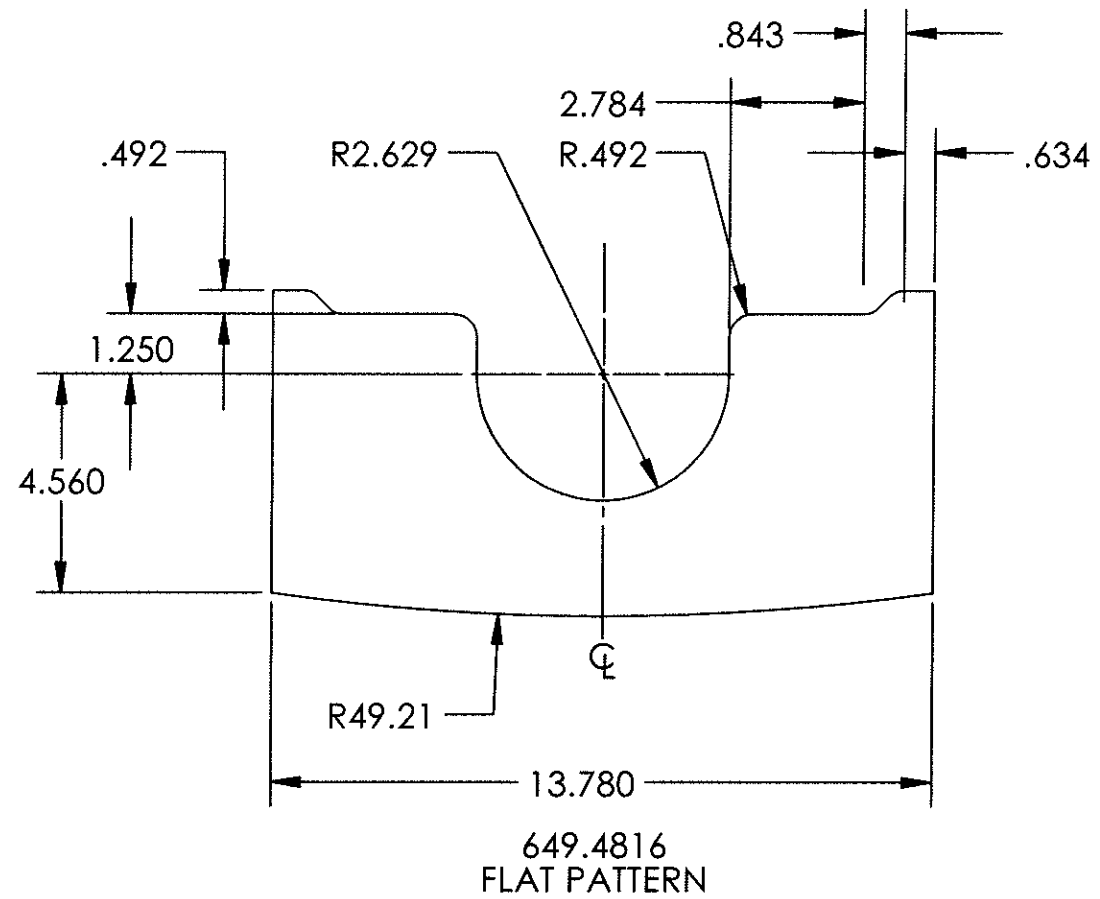
Ø.196

.25 X 45.0° 4PL

.750

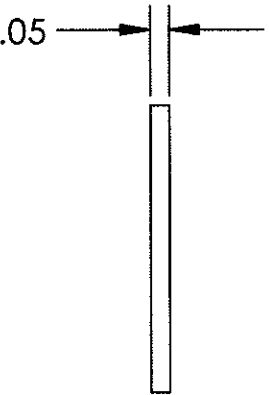
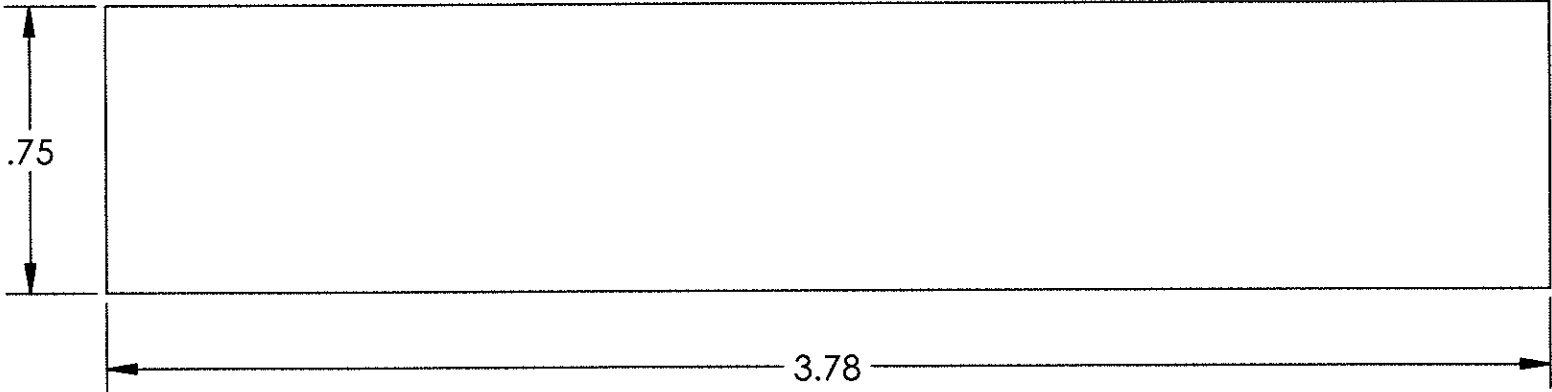
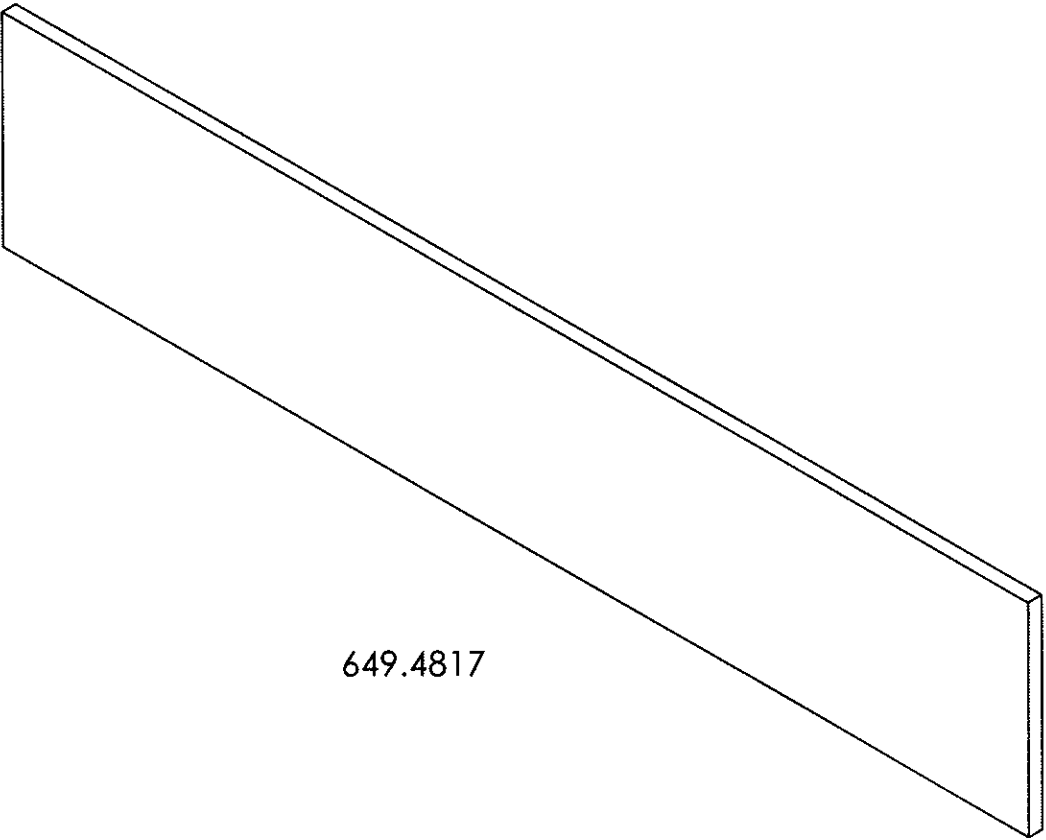
ORIGINAL DATE 11-02-11		<b>DART</b> AEROSPACE APICAL INDUSTRIES, INC. dba DART AEROSPACE		3030 ENTERPRISE CT., SUITE A VISTA, CA. 92081 (760)-724-5300	
DRAWN BY A. QUAN				CHECKER P. BRAVO	
DRAWING APPROVAL P. BRAVO 11-02-11					
CONTRACT No.					
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.03 3 PLACE DECIMALS ±.010 ANGLES ±.5°		SIZE B		CAGE CODE 07MZ6	DWG. NO. 649.4800
		SCALE NONE		REV. E	
		SHEET		4 OF 8	

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ORIGINAL DATE (MO-DA-YR) 11-02-11		<b>DART</b> AEROSPACE		3030 ENTERPRISE CT., SUITE A VISTA, CA. 92081 (760)-724-5300	
DRAWN BY A. QUAN		CHECKER P. BRAVO		APICAL INDUSTRIES, INC. dba DART AEROSPACE	
DRAWING APPROVAL P. BRAVO 11-02-11		CONTRACT No.		SHEETMETAL	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.03 3 PLACE DECIMALS ±.010 ANGLES ±.5°		SIZE B	CAGE CODE 07MZ6	DWG. NO. 649.4800	REV. E
		SCALE NONE			SHEET 5 OF 8

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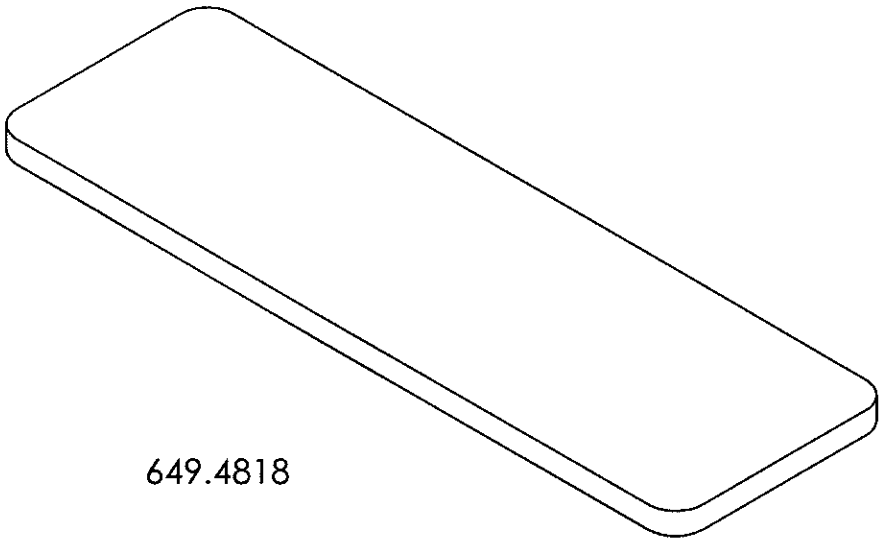
ORIGINAL DATE (MO-DA-YR)	11-02-11
DRAWN BY A. QUAN	CHECKER P. BRAVO
DRAWING APPROVAL P. BRAVO (11-02-11)	
CONTRACT No.	

UNLESS OTHERWISE SPECIFIED  
DIMENSIONS ARE IN INCHES  
TOLERANCES ARE:  
2 PLACE DECIMALS ±.03  
3 PLACE DECIMALS ±.010  
ANGLES ±.5°

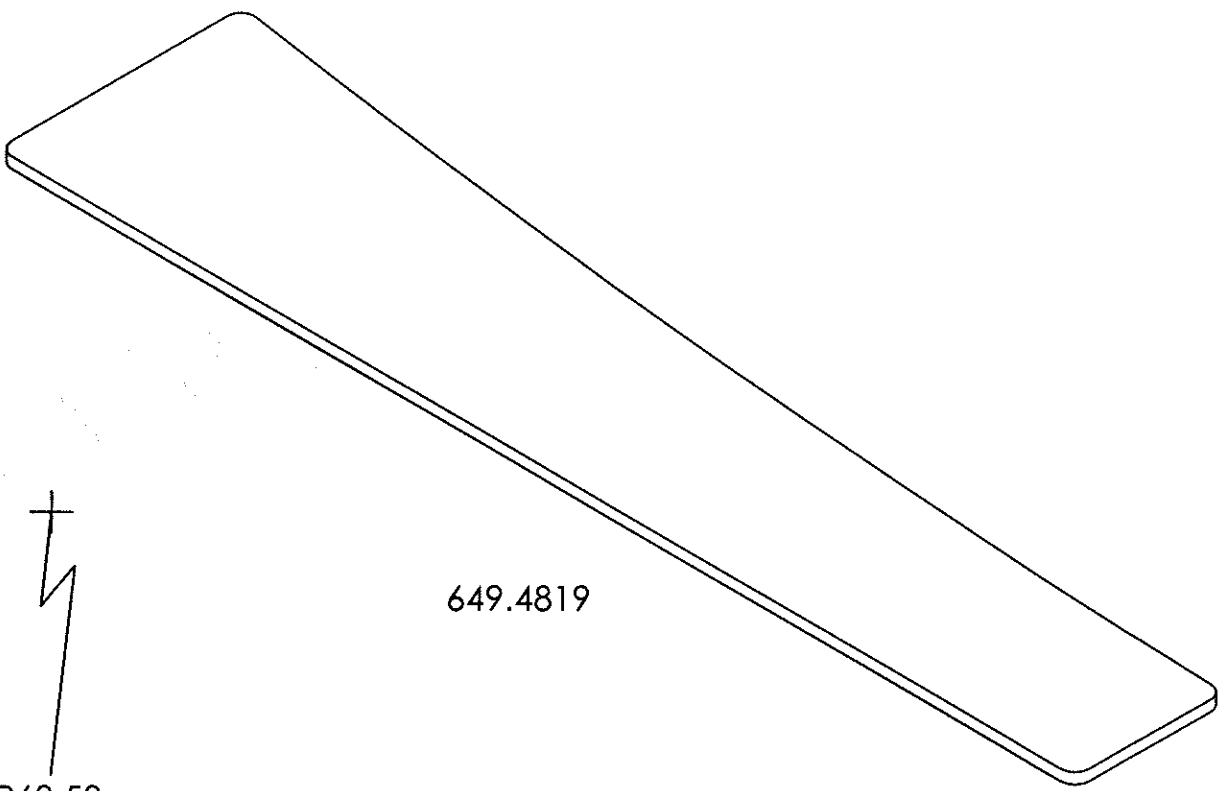
		3030 ENTERPRISE CT., SUITE A VISTA, CA. 92081 (760)-724-5300	
APICAL INDUSTRIES, INC. dba DART AEROSPACE			
SHEETMETAL			
SIZE B	CAGE CODE 07MZ6	DWG. NO. 649.4800	REV. E
SCALE NONE		SHEET 6 OF 8	

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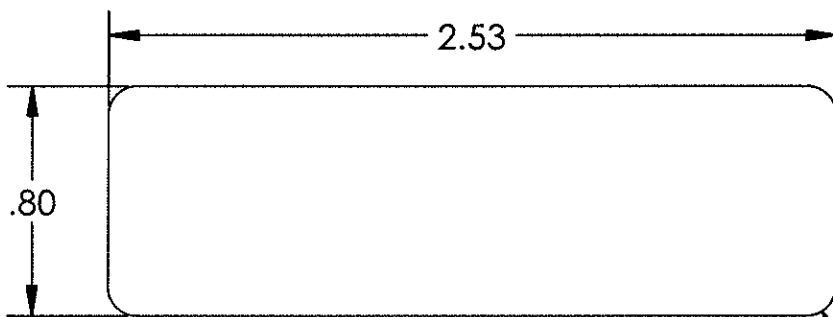
A  
B  
C  
D



649.4818

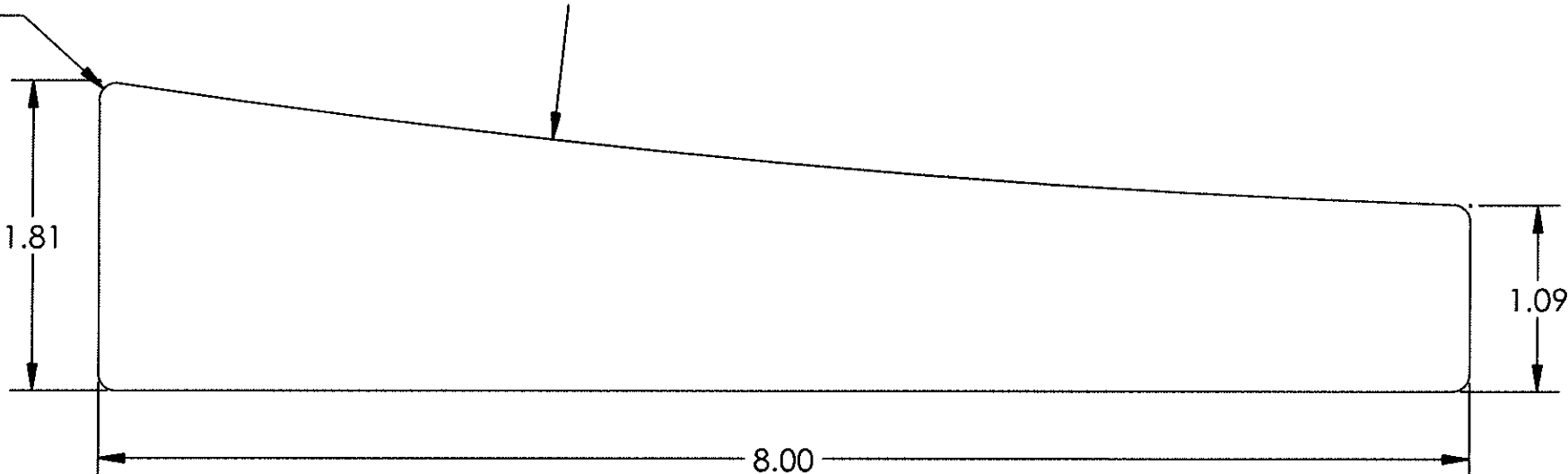


649.4819



2.53

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R.10

R68.53

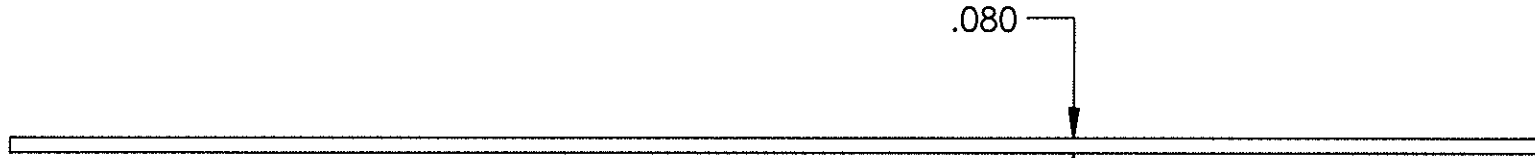
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1.09



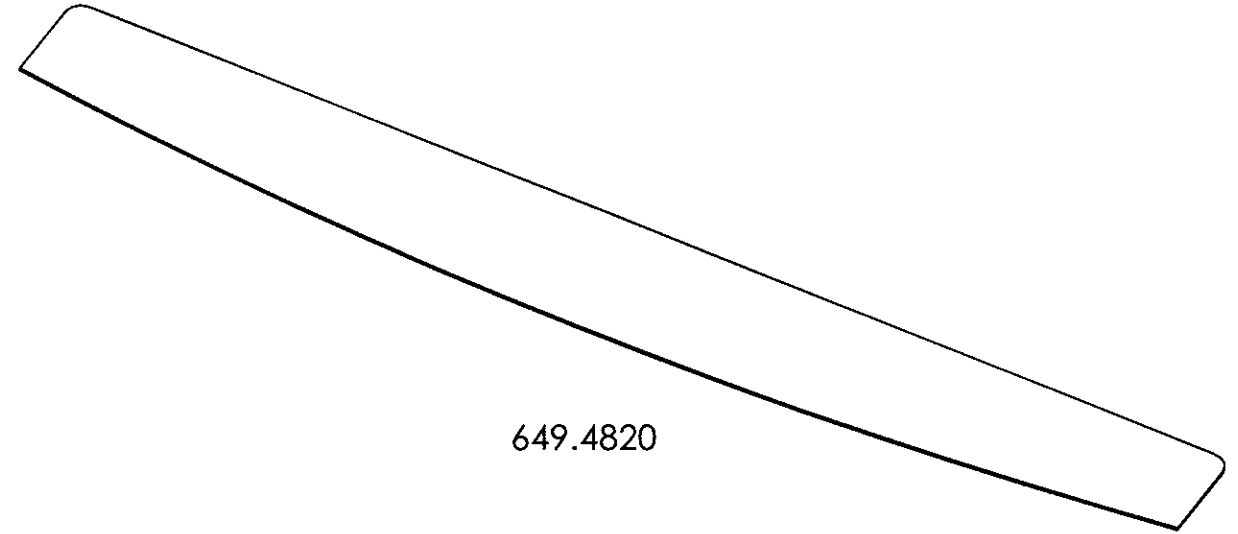
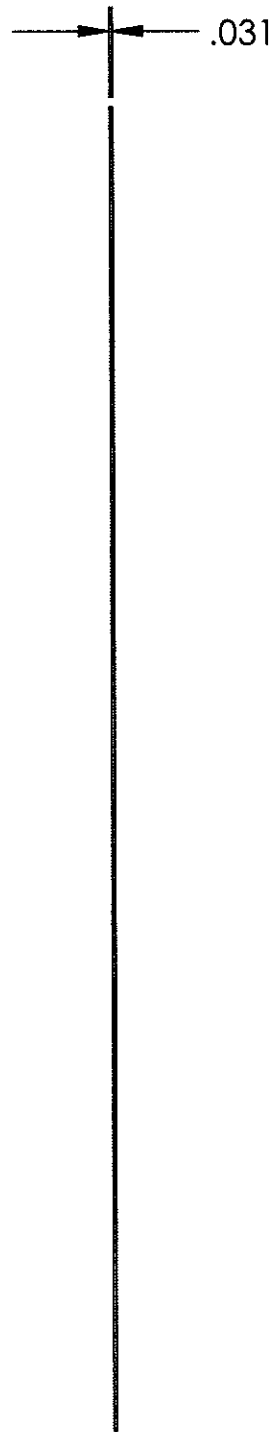
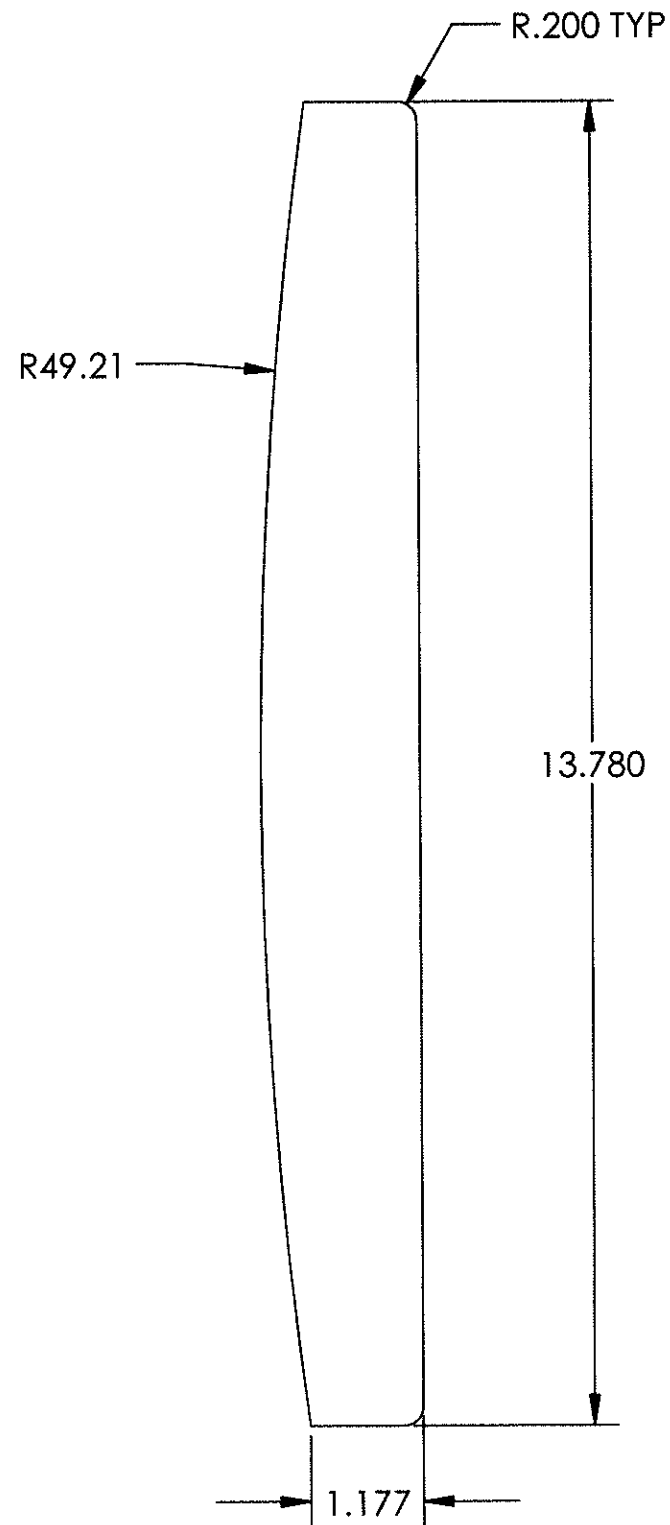
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ORIGINAL DATE 11-02-11		<b>DART</b> AEROSPACE APICAL INDUSTRIES, INC. dbg DART AEROSPACE		3030 ENTERPRISE CT., SUITE A VISTA, CA. 92081 (760)-724-5300	
DRAWN BY A. QUAN				CHECKER P. BRAVO	
DRAWING APPROVAL P. BRAVO 11-02-11				CONTRACT No.	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.03 3 PLACE DECIMALS ±.010 ANGLES ±.5°				SHEETMETAL	
SIZE B	CAGE CODE 07MZ6	DWG. NO. 649.4800		REV. E	
SCALE NONE				SHEET 7 OF 8	

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ORIGINAL DATE (MO-DA-YR) 11-02-11		<b>DART</b> 3030 ENTERPRISE CT., SUITE A VISTA, CA. 92081 (760)-724-5300 APICAL INDUSTRIES, INC. dba DART AEROSPACE			
DRAWN BY A. QUAN	CHECKER P. BRAVO				
DRAWING APPROVAL P. BRAVO 11-02-11					
CONTRACT No.		SHEETMETAL			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm .01$ 3 PLACE DECIMALS $\pm .005$ ANGLES $\pm .5^\circ$		SIZE B	CAGE CODE 07MZ6	DWG. NO. 649.4800	REV. E
		SCALE NONE		SHEET 8 OF 8	